

Work Order ID 117596-2 <sup>M24 12</sup> ~~D5061-1~~ \*117596\*

April-28-14 11:13:26 AM

Page 1

Item ID: D5061-1

Revision ID:

Item Name: Fwd Wearplate

Start Date: 4/28/14

Start Qty: 10.00

\*10\*

Required Date: 5/12/14

Req'd Qty: 10.00

\*10\*

Reference:

\*N900004 100\*

Setup Start \*IS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MCS

Date: 4-24-28 Tooling:

Date:

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5061

A

110

\*110\*

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1- Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

0.00

12

mm/Jm 17/04/30

120

\*120\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

12

mm/Jm 17/04/30

130

\*130\*

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

M/S/1

12



## Work Order ID 117596

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**\*117596\***

Page 2

Item ID: D5061-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Wearplate  
 Start Date: 4/28/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 5/12/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> Brake NC Brake NC	Form as per dwg NC BRAKE  Memo Form joggle as per dwg.	0.00  0.00			DAS 30 9-89	12			2/25/15
150 <b>*150*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00				12			14/5/15
160 <b>*160*</b> Large Fab Large Fab	Large Fab  Memo Weld hard surface as per QSI 004 and Dwg D5061 2059 Hardcoat Rod <b>m127456</b>	0.00  0.00				10		14-06-18	MAL P10 →

DONE WITH MODIFICATION  
 TO DRAWING SEE ROSS ON  
 DRAWING. DRAWING TO BE  
 REVISED TO REFLECT  
 CHANGES.  
 USE AS IS

*[Signature]*  
 JUNE 24, 2014





DQA:

Date:

14/12/17



QA Closed:

Date:

14/8/27

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>117596</u>	<b>DISPOSITION</b>		<b>AGAINST DEPARTMENT/PROCESS</b>			
Part No. <u>D5061-1</u>	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/>	
NCR No. <u>14-4198</u>	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input checked="" type="checkbox"/>				Due to design issue	DAS 16 9-89	Cut groove in centre of fus ends of work piece AS per RS 1017	14-06-24 MAL	14-06-24	DAS 16 9-89
Doc/Data <input type="checkbox"/>				Wear plate doesn't fit accordingly.	14/06/24				
Equip/Tooling <input type="checkbox"/>				RC: Design	Q52012	open PAR to correct drawing			14/06/24 Q52012
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									


## FAULT CATEGORY

<b>Landing Gear</b>		<b>General</b>			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input checked="" type="checkbox"/> Other	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread			
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set			
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence			



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 11 7596
<b>Description: D5061-1 FWD WEARPLATE</b>	
<b>Drawing: D5061-1</b>	<b>Repair Scheme: RS1017</b>
<b>Part No: D5061-1</b>	<b>Page: 1 of 1</b>
<b>Batch No:</b>	<b>Qty: 1</b>

Step	Location	Procedure	By	Date	Qty
1	Large Fab / Welding	Pull all affected D5061-1 B117596	MAL	14-06-24	10
2	Large Fab / Welding	Cut a tapered slot in fwd end of wearplate 3/32" to 1/16" (fwd - aft) 1.00" in length	MAL	14-06-24	10
3	Large Fab / Welding	Weld as per QSI004 A/R <u>M125054</u>	MAL	14-06-24	10
4	QC	Buff weld smooth	MAL	14-06-24	10
5	QC	QC9 inspect weld	DAS 9 2.00	14-06-24	10
6	QC	QC5 inspect work completeness	Smf	14/6/25	10
7	Finishing	Apply Rockgard as per Dwg A/R Rockgaurd Batch # _____ Expiry Date _____			
8	QC	QC 3 Inspect Finish			
9	QC	QC5 inspect competence of work			
10	Stores	Identify and stock			
11	QC	QC21			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.6.24	New Issue	ED		

U:\Admin\Forms\Repairschemb1A.doc

Rev. A







# Work Order ID 117596

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**\*117596\***

Page 3

Item ID: D5061-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Wearplate  
 Start Date: 4/28/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 5/12/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									DAS 9 200
180	QC5- Inspect part completeness to step on W/O	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									
183		0.00							
<b>*183*</b>									
HandFinish	Memo	0.00							
Hand Finishing	APPLY ROCKGARD AS PER DWG								
	A/R ROCKGARD BATCH: <u>129597</u>								

10 14-06-24

14/6/25

10

10 0 0 AS  
14-6-25



# Work Order ID 117596

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\*117596\*

Page 4

Item ID: D5061-1 Accept \*N900040100\* Setup Start \*NS1\*  
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 Start Date: 4/28/14 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 5/12/14 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
186 *186* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	<i>23</i> <i>14/6/26</i>	DAS 27 9-89		<i>(10)</i>			
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <i>IP-002</i> Packaging Memo	0.00 0.00				<i>x10</i>	<i>d</i>	<i>all</i>	<i>x106/26</i>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00				<i>mcs</i>	<i>14-06-26</i>		<i>14-6-26</i>





# Picklist Print

April-28-14 11:13:29 AM

Page 1

Work Order ID: 117596

\*117596\*

Parent Item: D5061-1

\*D5061-1\*

Parent Item Name: Fwd Wearplate

Start Date: 4/28/14

Required Date: 5/12/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.02.13 NEW ISSUE DD VERF:JLM IPP  
REV:B 14.03.12 rev.A10 DD VERF:JLM IPP REV:c  
14.04.21 rev.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA		Purchased	No				sf	628.7100					
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\*M304S18GA\*

304/316 .050 Sheet

\*\*

45 sq ft.

DAS  
23  
9-89

14-04-30

Location	Loc Qty	Loc Code
MAT019	616.71	
117188	3	
117766	5	
120604	5	
122325	3	
123155	3	
124572	38	
M126647	39.75	
M128254	108.71	
M128435	187.25	
M128864	224	
MAT020	12	
124029	2	
M126098	10	

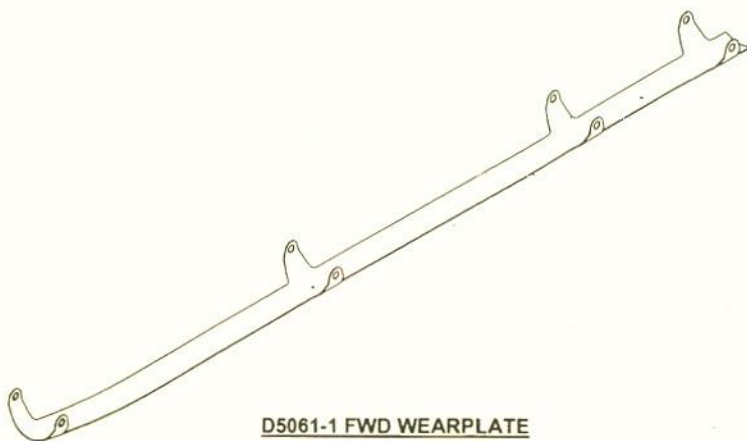
128864.

602

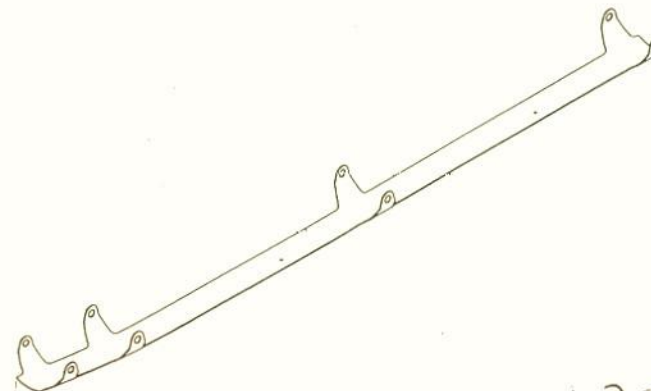








D5061-1 FWD WEARPLATE



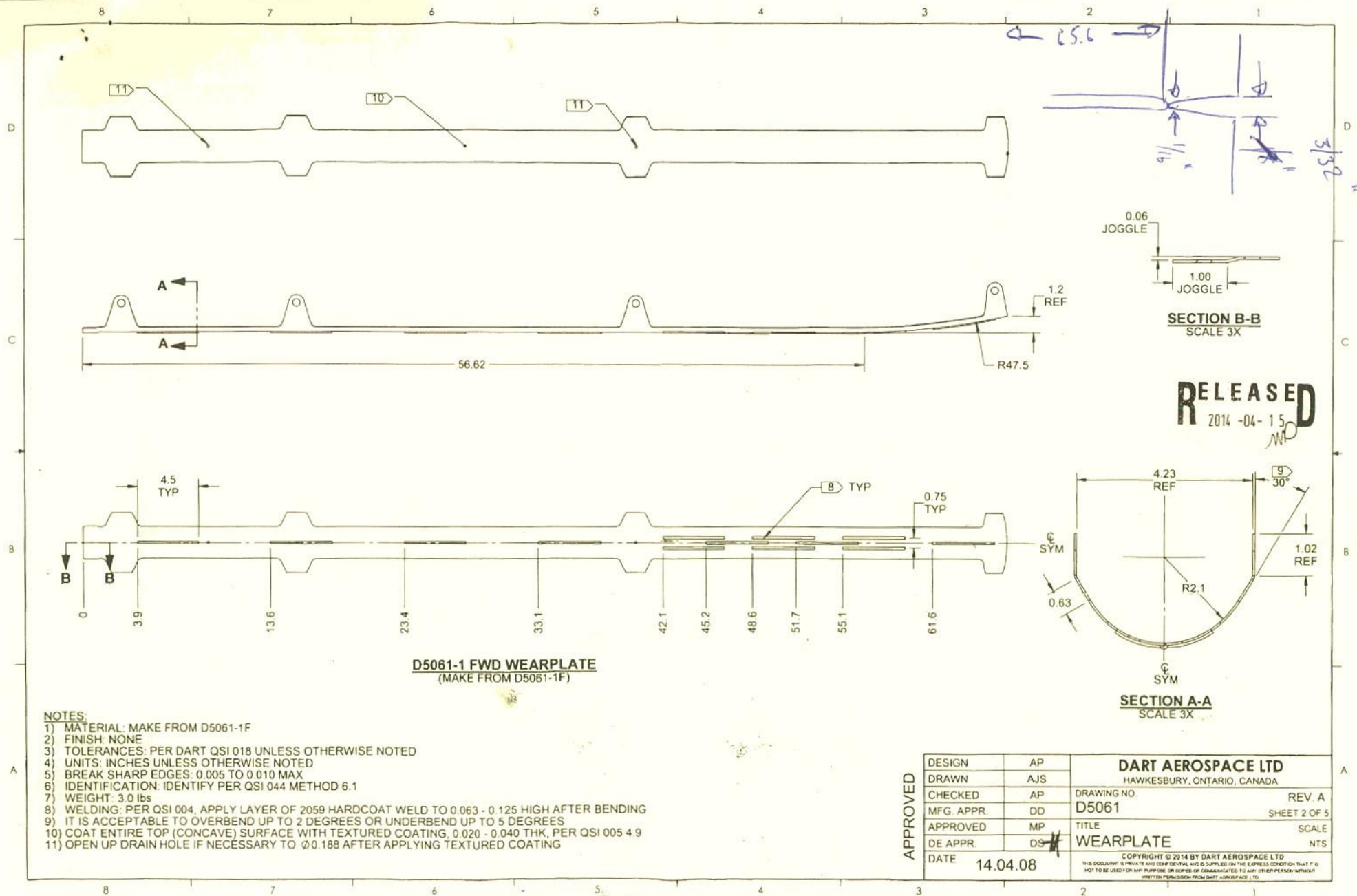
D5061-3 AFT WEARPLATE

1175916 MJS  
1404-28

**RELEASED**  
2014-04-15  
MJS

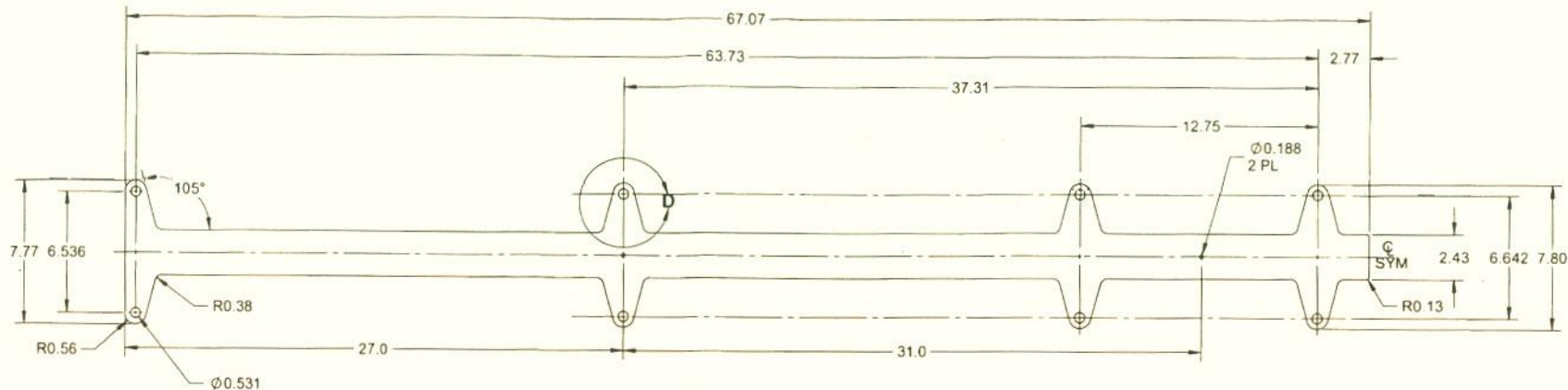
APPROVED	A		NEW ISSUE		AP	14.04.08	
	REV.	DESCRIPTION				BY	DATE
	DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA				
	DRAWN	AJS					
	CHECKED	AP	DRAWING NO.	REV. A			
	MFG. APPR.	DD	D5061	SHEET 1 OF 5			
APPROVED	MP	TITLE	SCALE				
DE APPR.	D8	WEARPLATE	NTS				
DATE		14.04.08		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



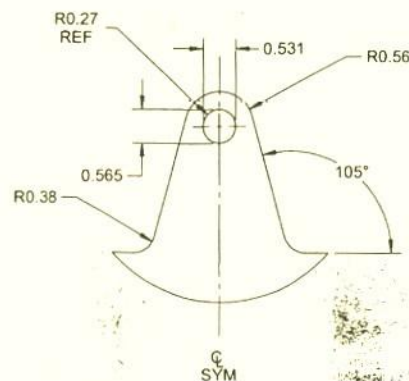








**D5061-1F FWD WEARPLATE**



**DETAIL D**  
SCALE 3X  
3 PL

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

**RELEASED**  
2014-04-15

DESIGN	AP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR	DD	D5061	SHEET 4 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR	DS	WEARPLATE	NTS
DATE	14.04.08	<small>COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

